

Date: Tuesday, 5/23/2006 8:12:53 AM
 User: Kim Johnston

Process Sheet

| | | | |
|-------------------------|-------------------------------------|--------------------|-------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | STRUT |
| Job Number : | 27164 | | |
| Estimate Number : | 10272 | | |
| P.O. Number : | N/A | Part Number : | D2562001 |
| This Issue : | 5/23/2006 S.O. No. : N/A | Drawing Number : | D2562 REV D |
| Prsht Rev. : | NC | Project Number : | N/A |
| First Issue : | N/A Type : SMALL/MED FAB | Drawing Revision : | D |
| Previous Run : | 25969 | Material : | N/A |
| Written By : | | Due Date : | 6/4/2006 |
| Checked & Approved By : | <u>JA.06.05.23</u> | Qty: | 20 Um: Each |
| Comment : | Est F 02.04.15 Added dwg Rev.B1 NG | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TR0500W035 | 304 RD Tube .500 x .035W |
|-----|----------------|--------------------------|



Comment: Qty.: 1.7920 f(s)/Unit Total : 17.9204 f(s)
 304/316/318-2B Seamless Tubing, 1/2" O.D. x 0.035" wall
 Batch M101593

FF 06.08.08 20

| | | |
|-----|----------|----------|
| 2.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE
 Punch to length as per Dwg D2562

FF 06.08.08 20

| | | |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL/MED FAB RESOURCE
 1- Bend end as per Dwg D2562 Angle "D"
 2-Debur ml 06/08/09

SB 04/08/15

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

JA.06.06 (20)

| | | |
|-----|----------------|----------------|
| 5.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|



Comment: POWDER COATING
 Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005.4.3

FC 06 09 11 (20)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 26/07/12

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 8:12:54 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 27164

Part Number: D2562001

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

106/8/12 20

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 3184

RB 06/09/12 20

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/09/12 20

Job Completion



U 06-09-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design.Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

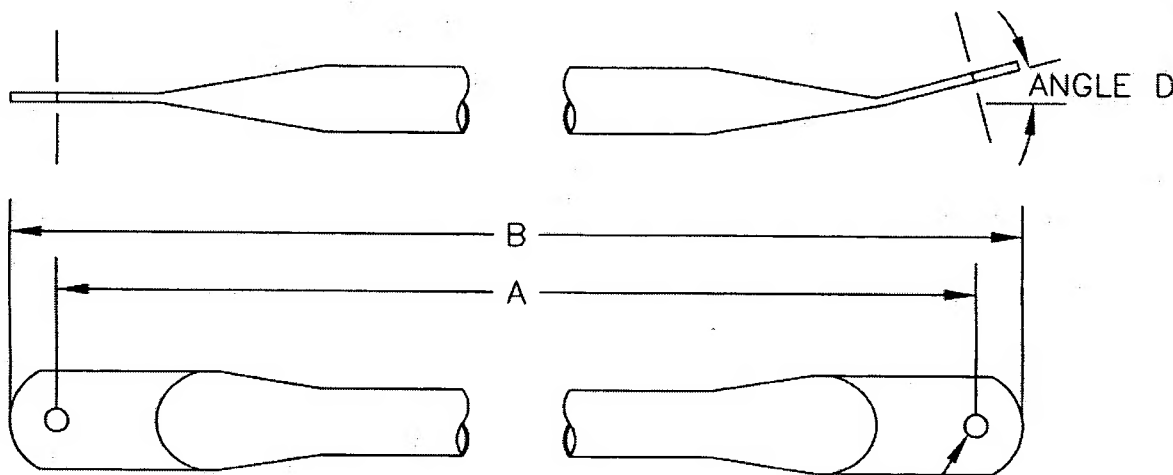
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

| DESIGN | DRAWN BY | DART AEROSPACE LTD | |
|----------|----------|----------------------------------|--------------|
| CP | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. D |
| | | D2562 | SHEET 1 OF 1 |
| DATE | TITLE | SCALE | |
| 05.05.18 | STRUT | 1:2 | |
| A | 96.05.01 | NEW ISSUE | |
| B | 98.10.15 | UPDATED MATERIAL NOTE (TSR A603) | |
| C | 02.06.05 | ADD -005; ADD FINISH | |
| D | 05.05.18 | ADD -007/-011/-013; UPDATE -005 | |



PUNCH ENDS PER SPEC CONTROL DRAWING D2727

| PART # | DIM A | DIM B | DIA C | ANG D |
|-------------|-------|-------|-------|-------|
| ✓ D2562-001 | 19.68 | 20.48 | - | 10 |
| D2562-003 | 20.37 | 21.17 | - | 18 |
| D2562-005 | 29.00 | 29.80 | - | 30 |
| D2562-007 | 19.22 | 20.02 | - | 0 |
| D2562-011 | 25.79 | 26.59 | - | 16 |
| D2562-013 | 26.63 | 27.43 | - | 24 |
| | | | | |
| | | | | |
| | | | | |
| | | | | |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27164

RELEASED

06.05.27

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035) ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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